

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-001409**Date Inspected:** 02-Feb-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See Below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower and OBG Fabrication**Summary of Items Observed:**

altrans Quality Assurance (QA) Inspector, Mr. Paul Dawson, arrived on site at the Zhenhua Port Machinery Company (ZPMC) facility at Changxing Island, in Shanghai, China, for the purpose of monitoring welding and fabrication of the San Francisco / Oakland Bay Bridge (SFOBB) components. The QA Inspector observed the following:

Orthotropic Box Girder (OBG) and Tower Mock Up:

CWI Inspector: Mr. Xu Xian Ping

The QA Inspector observed no welding to be taking place in bay 2 or bay 3. Note: Many of the ZPMC workers are observing the Chinese Lunar New Year holiday and are not working today.

Bay 3

The QA Inspector performed random visual inspections and magnetic particle (MT) inspections of portions of OBG side plate SP019 stiffener fillet tack welds SP019-01-013 through SP019-01-023. The plate is clamped to a pre-camber table in order to minimize final weld distortion. ZPMC QC magnetic particle inspector Mr. Cai Xinxin had marked "MT OK" on the base material adjacent to where these tack welds are located. The welds that were MT inspected appear to comply with project specifications. QA Inspector visually observed several of these tack welds have small pieces of slag at the ends of the welds. The QA Inspector showed ZPMC QC CWI Inspector Mr. Xu Xianping one of these locations with the slag and Mr. Xu Xianping had the slag removed. Mr.

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Xianping said he will visually inspect the remainder of the side plate tack welds to ensure no other slag is at the ends of the tack welds. The QA Inspector observed Mr. Xianping marked approximately ten locations where slag needs to be removed at the ends of the welds, and ZMPC personnel used a chipping hammer to remove the slag. See the photographs below for additional information.



Summary of Conversations:

See above for summary of conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By:	Dawson,Paul	Quality Assurance Inspector
Reviewed By:	Cochran,Jim	QA Reviewer
